

Work Order ID 87889

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July-17-12 2:44:40 PM

Item ID: D3825-041

Revision ID:

Item Name: Rib Assembly (Basket End)

Start Date: 7/17/12 Start Qty: 6.00

Required Date: 7/17/12 Req'd Qty: 6.00

Reference: ECN12-603 REWORK

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

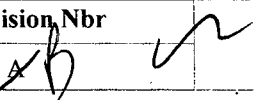
Customer:

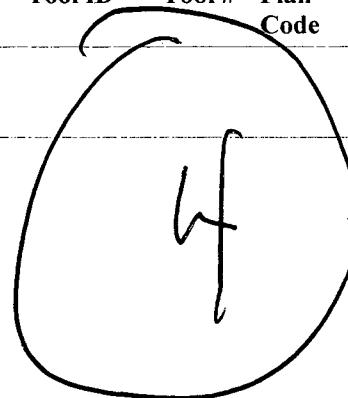
Approvals: Process Plan:  Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3825	Rev A 								
100	Large Fab	0.00							
100									
Large Fab									
Large Fab									
	Memo	0.00							
	PULL FROM STK:								
	6 X D3825-041 B83913								
	REWORK PER QRWG D3825 REV.B								
	PER ECN12-603								
	1- cut D3825 1 rib as per dwg D3825 <i>N/A w 120717</i>								
	2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825 <i>for BUSH D4021-9 120716</i>								
	3- c/sink hole as per dwg								
	4- remove identification markings								
	5- deburr <i>D4021-9 120716</i>								
	6- weld D3750 1 bushing as per dwg D3825								
	A/R S.S. Rod Batch: <i>1171602</i>								
	7- grind bushing weld flush where indicated on dwg D3825								
	8- deburr if necessary								



LD/CC 17-7-20

87889

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N900040100

Setup Start *NS1*

Stop *NS2*

6

6

Reference: ECN12-603 REWORK


Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Packaging

RE-IDENTIFY USING NEW B/N

4 12.7.25 

17/6/75

CC 17-7-25 (4x)

Work Order ID 87889

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Item ID: D3825-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Rib Assembly (Basket End)
 Start Date: 7/17/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 7/17/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference: ECN12-603 REWORK

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/2/26
 12-07-26

Picklist Print

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Page 1

Work Order ID: 87889

Parent Item: D3825-041

Parent Item Name: Rib Assembly (Basket End)

Start Date: 7/17/12

Required Date: 7/17/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1 Bushing	D4021-9	Manufactured	No				Each	142.0000		4		CC 12-7-20	
-----------------	---------	--------------	----	--	--	--	------	----------	--	---	--	------------	--



Location

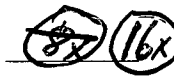
WA
79213
83464
WA005
66489
82785

Loc Qty

140
1
139
2
1
1

Loc Code

B84717 →



D3825-041
Rib Assembly (Basket End)

Manufactured No

Each 0.0000

83913 → CC 12-7-20

?

8

7

6

5

4

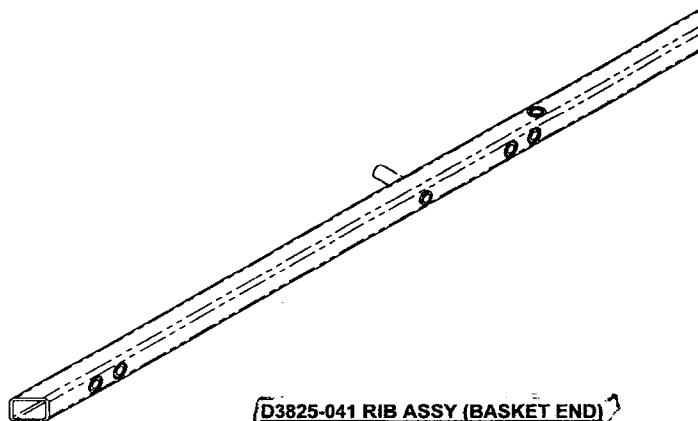
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2

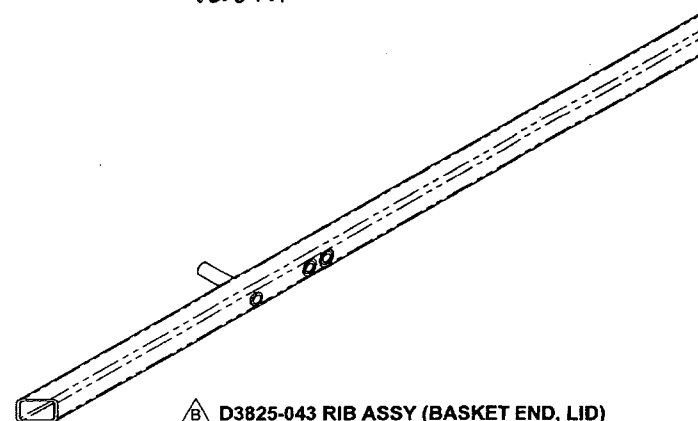
1

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3825-041	RIB ASSEMBLY (BASKET END)
		X	D3825-043	RIB ASSEMBLY (BASKET END, LID)
1		1	D2327-1	SPACER BUSHING
2	1		D2327-3	SPACER BUSHING
3	1	1	D2327-1	BUSHING D 5759-1 (OV)
4	1		D3825-1	RIB
5		1	D3825-3	RIB
6	4	2	D4021-9	DUSHKIN

12.07.18



D3825-041 RIB ASSY (BASKET END)



D3825-043 RIB ASSY (BASKET END, LID)

RELEASED
R 2012-07-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3825-041 = 1.25 lbs; D3825-043 = 1.23 lbs.
- 8) WELDING: PER DART QSI 004

B	QTY(5) FOR D3759-1 WAS QTY(1); AFFECTS D3825-041/-1 (ZNS D3-1, C4-2, C3-2, D4-4, C6-4, C4-4, C3-4). ADDED D3825-043/-3.	MB	12.05.11
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.05.11		

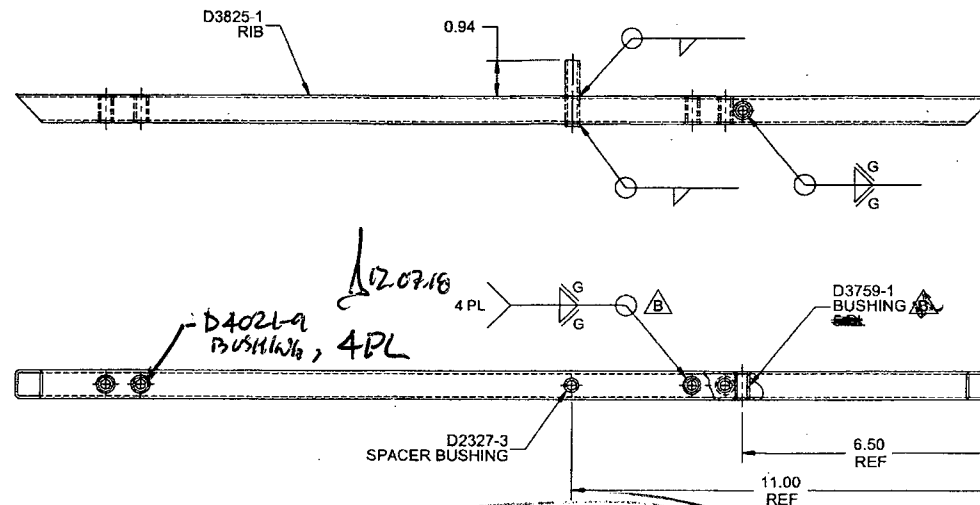
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3825	REV. B SHEET 1 OF 4
TITLE RIB ASSY (BASKET END)	SCALE NTS

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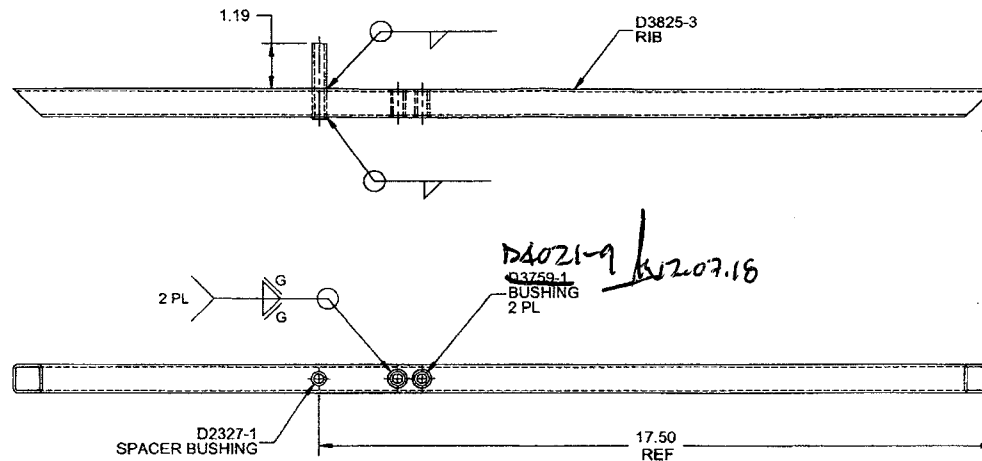
(87913)



D3825-041 RIB ASSY (BASKET END)

RELEASED
2012-07-16

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3825	REV. B
MFG. APPR.		SHEET 2 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	12.05.11	<small> COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD </small>	



D3825-043 RIB ASSY (BASKET END, LID)

RELEASED
2012-07-16

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3825 REV. B
MFG. APPR.		SHEET 3 OF 4
APPROVED		TITLE RIB ASSY (BASKET END) SCALE NTS
DE APPR.		
DATE	12.05.11	

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8 7 6 5 4 3 2 1

D

D

C

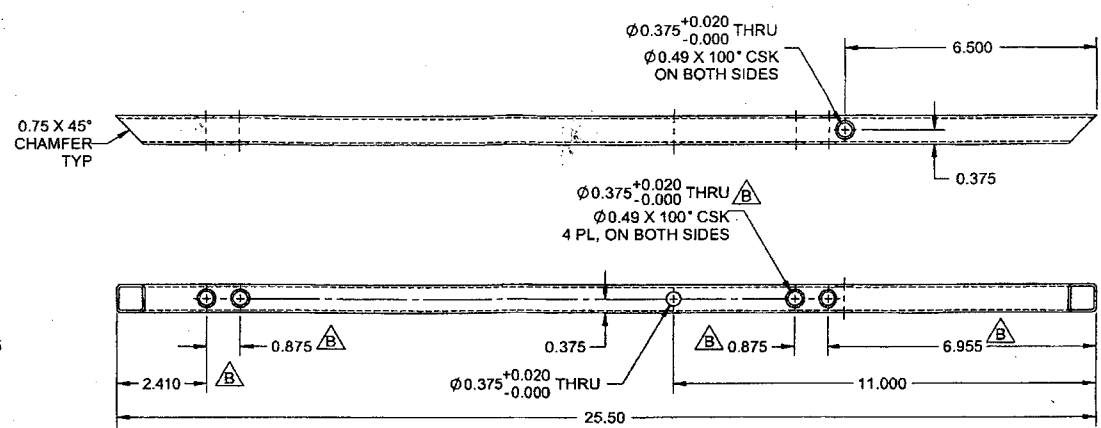
C

B

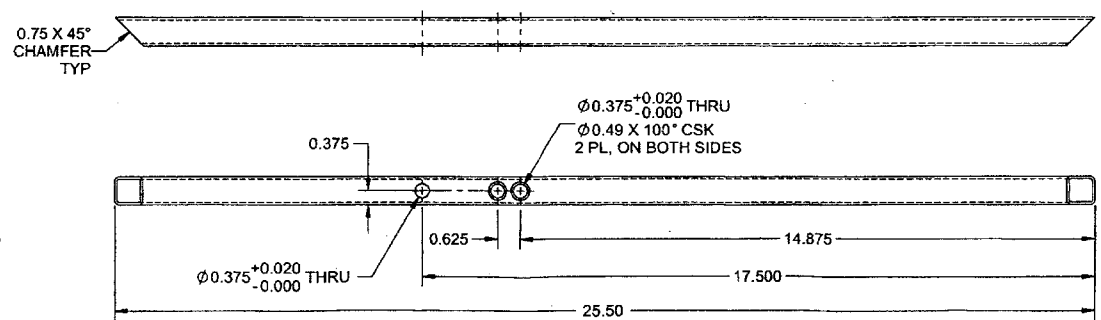
B

A

A



D3825-1 RIB



D3825-3 RIB

RELEASED
2012-07-16
ND

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.16 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. B
MFG. APPR.		D3825 SHEET 4 OF 4
APPROVED		TITLE SCALE
DE APPR.		RIB ASSY (BASKET END) NTS
DATE	12.05.11	

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8 7 6 5 4 3 2 1

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 12.07.11	Job No.: ENG3105	ADR Yes/No: Y	ADR Date: 12.05.11	ECN #: 12- 603
Product No.: D350-607-041/-043/-045/-047	Created By: <i>[Signature]</i>	Approved By: <i>[Signature]</i>		
Product Name: HELI-UTILITY-BASKET	Checked By: <i>[Signature]</i>			

Distribution	Reqd	Resp	Initial / Date
Production Manager / Coord.	Y	LL/MF	
Purchasing Coord.	N		
Production Engineering Coord.	Y	DD	
		EC	
		JLM	

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord.	Y	PS	
QC Coordinator	Y	ED	
Customer Technical Support	N		
Marketing	N		
Customer Order Processing	N		

Reason for Change:

CONTINUOUS IMPROVEMENT BASED ON PAR 10-50.

Documents Affected:

RELEASE D2512 REV. F, D3265, D3267 REV. D, D3266, REV. C, D3825, D3832, D3833, D3836 REV. B

PAPERWORK UPDATE ☐

PARTS MUST COMPLY ☒

PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	MB	MDL-D350-607 REV. H	12.07.11
6	Update Product Compatibility Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		
11	Update Product Specification Files	N			
12	Update Approved/Preliminary Dwg PDF Files	Y	KJ		12.07.16
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Create/Update Parts / STC Database	Y	KJ	SEE BELOW.	12.07.16
17	Update / Verify ARC Database	Y	KJ		12.07.16
18	Create / Update Change Record Form / Item Card Database	Y	KJ	SEE BELOW.	
19	Create / Update PPP's	Y	KJ		
20	Red Decals required?	Y	KJ		
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ	WITH ADR AND MDL	
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		
24					

Description / Action:

- ADD D3265-043/-7, D3825-043/-3, D3832-7/-9/-11/-13/-15, AND D3833-7 IN SYSTEM;
- REORGANIZE PARTS/BINS IN BASKET CELL;
- REVIEW ALL BOM'S AND W/O'S FOR D350-607-045/-047 BASKETS

NOTE ABOUT PARTS MUST COMPLY:

- D350-607-041/-043/-045/-047 IN STOCK/PROGRESS ARE ALL OK.
- D3825-041/-1 AND D3836-041/-042 IN STOCK WILL REQUIRE REWORK:

- D350-607-041/-041A NOW @ CHG 009/002 / D350-607-041AGB @ CHG002
- D350-607-043/-043A NOW @ CHG 006/002
- D350-607-045/-045A NOW @ CHG 004/002 / D350-607-045AGB @ CHG002
- D350-607-047/-047A NOW @ CHG 004/002

ECN Verified & Complete: _____ Date: _____